

Date: Tuesday, 10/06/2008 3:14:37 PM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number :	39808	Part Number :	D2573
Estimate Number :	10533	Drawing Number :	D2573 REV E
P.O. Number :		Project Number :	N/A
This Issue :	10/06/2008	Drawing Revision :	E
Prsht Rev. :	NC	Material :	
First Issue :	/ /	Due Date :	30/06/2008
Previous Run :	39475	Qty:	10 Um: Each
Written By :			
Checked & Approved By :	<u>JUL 08.6.10</u>		
Comment :	Est: 1 As Per RevE 06-01-27 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2573
Ensure that grain is along 7.75" length
Batch No: 34875

ML 08/07/06

(10)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 39808 Double check by: sf

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

ML / J.L 08/07/06

(10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2573 & D2574

ML / J.L 08/07/06

(10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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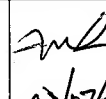

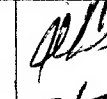

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML / J.L 08/07/06

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2573 PAR #: NA Fault Category: Red / Machined Part NCR: Yes No DQA: D Date: 08/07/10
D412-742 QA: N/C Closed: D Date: 08/07/10

NCR: <u>39808</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/06	2	1 piece scrap. the thickness of the skirt tube is not too thin of .040" R.C. the dowel pin broke inside the cross tube hole and start to vibrate (toddling)		Scrap and Destroy and Replace B34875	 08/07/06	 08/07/07	 08/07/07	 08/07/07
		to remove chatter the keyway will be 1/32 shallow						

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 3:14:37 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 39808

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

508/07/07 (10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 08-07-07 (10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:00

OVEN TEMPERATURE:

320

FINISH TIME:

11:30

BR 08/07/07 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-07-07 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

433

8/7/7

(10)

30

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/08 (10)

Job Completion



08-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 39808
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	7.998	7.999	8.000		
F	0.490	0.510		.491	.497	.496	.499		
G	0.257	0.262		.258	.258	.258	.259		
H	0.375	0.380		.377	.377	.377	.378		
I	0.490	0.510		.501	.500	.500	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.567	.567	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.123		
P	0.115	0.135		.122	.122	.124	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.251	.252	.252		
S	0.115	0.135		.120	.122	.117	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.229		
V	0.230	0.250		.240	.240	.238	.242		
W	0.115	0.135		.123	.125	.126	.129		
X	0.308	0.313		.310	.310	.316	.310		
Y	0.760	0.765		.760	.760	.766	.766		
Z	0.352	0.372		.366	.361	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.635	.631	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.248	.241	.247		
AE	1.500	1.520		1.513	1.513	1.516	1.518		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.253	.251	.248	.253		
AI	2.000	2.020		2.000	2.001	2.003	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	JL 19ML
Date:	08/07/04

Audited by:	
Date:	08/07/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 39808
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
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A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	7.999	8.000		
F	0.490	0.510		.502	.505	.502	.506		
G	0.257	0.262		.259	.260	.259	.259		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.500	.500	.500	.506		
J	1.174	1.184		1.180	1.180	1.179	1.179		
K	0.558	0.578		.566	.566	.566	.568		
L	1.174	1.184		1.180	1.180	1.179	1.179		
M	1.365	1.375		1.369	1.369	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.122	4.121	4.122	4.124		
P	0.115	0.135	125	.126	.125	.124	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.123	.127	.122	.123		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.228	3.228	3.228		
V	0.230	0.250		.240	.241	.242	.240		
W	0.115	0.135		.129	.130	.130	.128		
X	0.308	0.313		.310	.210	.310	.309		
Y	0.760	0.765		.760	.760	.760	.761		
Z	0.352	0.372		.360	.362	.361	.363		
AA	0.470	0.530		.506	.500	.500	.500		
AB	0.615	0.635		.628	.630	.631	.633		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.246	.246	.247		
AE	1.500	1.520		1.511	1.511	1.511	1.512		
AF	0.115	0.135		.125	.125	.126	.126		
AG	0.240	0.280		.260	.260	.260	.266		
AH	0.240	0.260		.250	.257	.250	.250		
AI	2.000	2.020		2.001	2.001	2.000	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	me
Date:	08/07/06

Audited by:	
Date:	08/07/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 39808
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
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B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.506	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.503	.504				
G	0.257	0.262		.259	.259				
H	0.375	0.380		.378	.378				
I	0.490	0.510		.499	.500				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.566	.568				
L	1.174	1.184		1.179	1.179				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.506	2.500				
O	4.119	4.129		4.123	4.122				
P	0.115	0.135		.125	.125				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.252	.252				
S	0.115	0.135		.122	.127				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.230	3.229				
V	0.230	0.250		.243	.242				
W	0.115	0.135		.129	.130				
X	0.308	0.313		.309	.310				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.361	.362				
AA	0.470	0.530		.506	.500				
AB	0.615	0.635		.636	.630				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.244	.247				
AE	1.500	1.520		1.512	1.511				
AF	0.115	0.135		.126	.126				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.256	.257				
AI	2.000	2.020		2.002	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

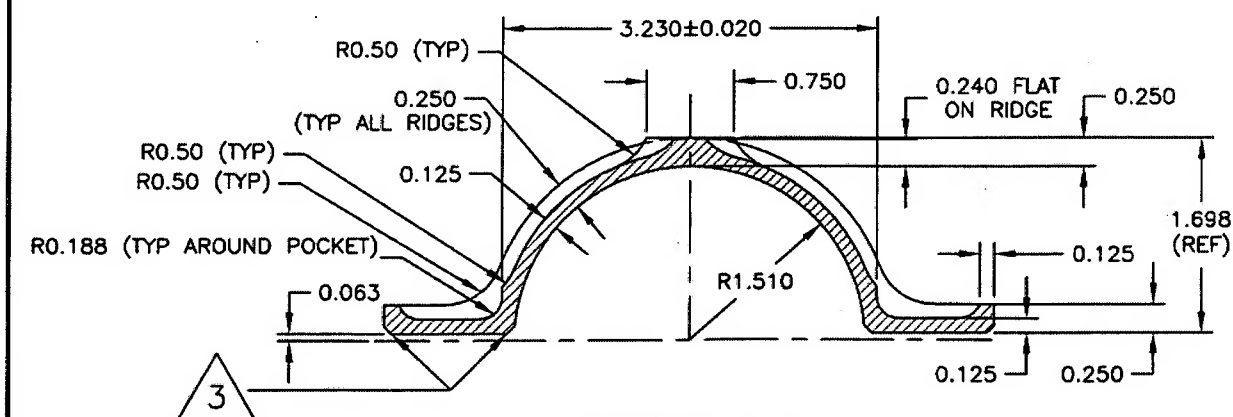
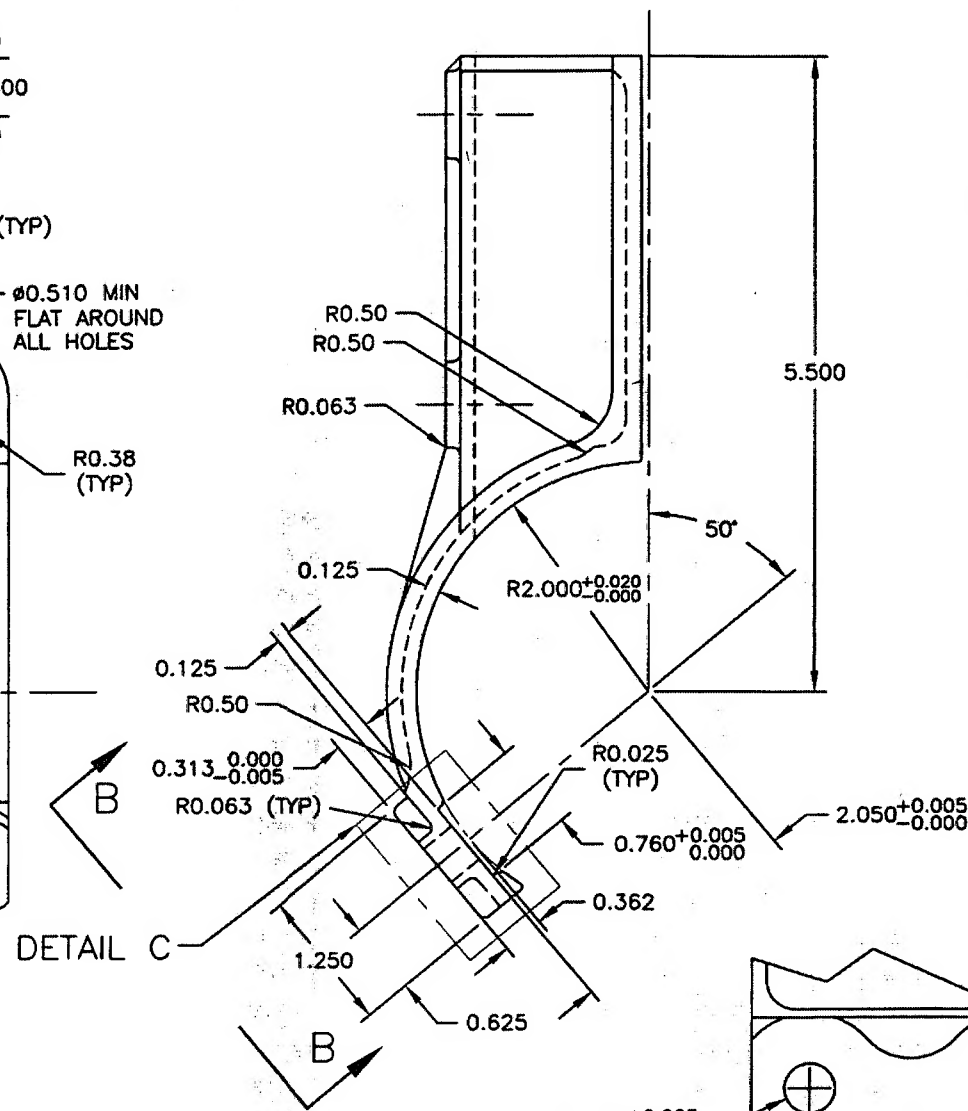
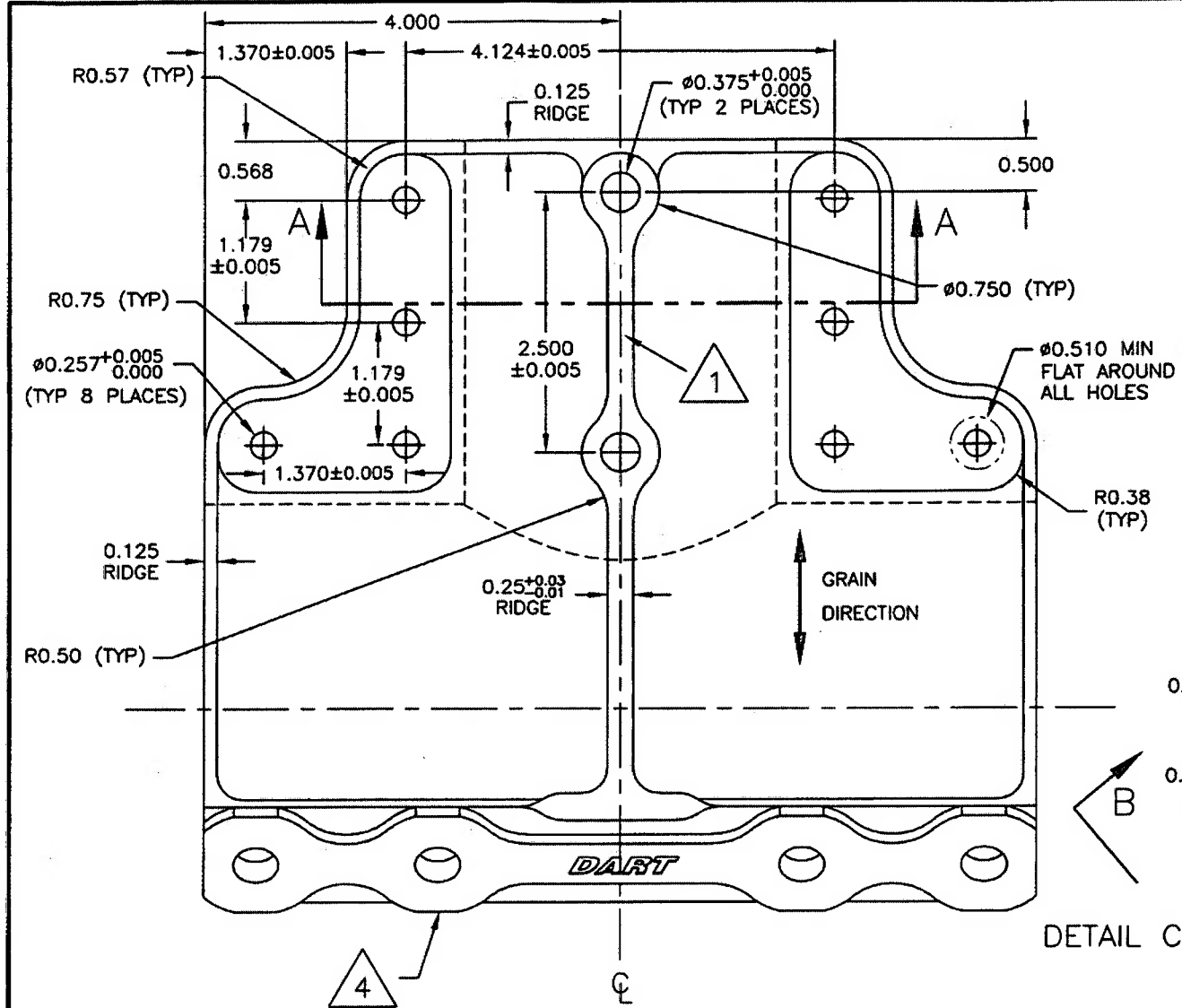
Measured by:	<i>gmk</i>
Date:	08/07/06

Audited by:	<i>S</i>
Date:	08/07/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>JA</i>

RELEASED

05.12.06



SECTION A-A

DETAIL C
SCALE 4:3

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39808

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN DS	DRAWN BY PH	DART DART AEROSPACE LTD. HAMMERSBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2573
DATE 05.07.13	TITLE OUTER AFT SADDLE	REV. E SHEET 1 OF 1 SCALE 2:3

